



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

ASAP

D5489-047
Job Sheet 182081



Part No: D5489-047

Job Qty: 4 ea

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/17/18

Job Tracking No:

Due Date: 8/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D5489 REV.B IPP REV:A 17.11.03 AS PER DWG REV.A DD VERF:JFS IPP REV:B 18.08.15 AS PER DWG REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	8/20/18	8/20/18	0.00	0.00	Start Up Waterjet		2-18/08/17
100	Waterjet	4 pcs	8/20/18	8/20/18	0.00	1.90	Waterjet1		2-18/08/17
110	QC	4 pcs	8/20/18	8/20/18	0.00	0.00	QC2 Waterjet-4		2-18/08/17
120	QC	4 pcs	8/20/18	8/20/18	0.00	0.00	QC8-6		AUG 23 2018
130	Brake NC	4 pcs	8/20/18	8/20/18	0.00	2.11	Brake NC 1		9-89
140	QC	4 pcs	8/20/18	8/20/18	0.00	0.00	QC5		67
150	Autoweld 1	4 pcs	8/20/18	8/20/18	0.00	3.52	Automated welding		AUG 28 2018
160	QC	4 pcs	8/20/18	8/20/18	0.00	0.00	QC10		AUG 28 2018
170	QC	4 pcs	8/20/18	8/20/18	0.00	0.00	QC5		AUG 28 2018
180	HandFinish	4 pcs	8/20/18	8/20/18	0.00	1.33	HandFinish4		AUG 30 2018
190	QC	4 pcs	8/20/18	8/20/18	0.00	0.00	QC3		AUG 31 2018
200	Packaging	4 pcs	8/20/18	8/20/18	0.00	0.00	Packaging3-2		AUG 31 2018
210	QC21-SA	4 Ea	8/20/18	8/20/18	0.00	0.00	QC21		AUG 31 2018

Part Op 100 - 1-Cut as per Dwg (D5489-7) Dwg Rev: B Prog Rev: B 2-Deburr if necessary
Descriptions: 150 - ***SEE NOTE 9 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: M138901
180 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG AND PER QSI005 A/R ROCKGUARD BATCH: 138886
200 - LOCATION : FP002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.6400 sf (.16 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	1	65	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		Cross tube ☐ " Esh ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐	
Date : _____	Step _____	MRB (QSI042) Approval	
Description Work Order		Completed By	
Lead hand / Supervisor Approval Verification		QC / QA Coordinator Approval	

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 Cambridge, ON K6L 1K7
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 Email: sales@dartaero.com
 www.dartaero.com

DART AEROSPACE
 Container No: S103348
 Part: D5489-047
 Job No: 182081
 Serial No/Batch: S103348
 Revision: B
 Inspector:
 Exp Date:
 Instructions: Various STC's

Date: 08/17/18

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐
OTHER : _____			

☐ Pressure/Forced	☐ Temperature/Cure	☐ rge	☐ Positioned Wrong
☐ Bending	☐ Set-up	☐ Grain	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Weld	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Wrong Stock Pulled	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Out of Sequence	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Off-set	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Mislabeled	☐ Drawing
☐ Heat Treat	☐ Cut Too Short	☐ Fit/Function	☐ Finish
☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Misaligned/off center	☐ Misread
☐ Marks/Chatter	☐ Drill Holes		☐ Turning Sequence

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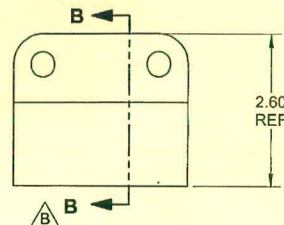
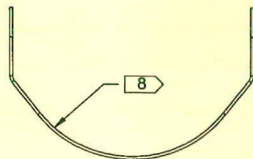
Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Date : 18/8/28	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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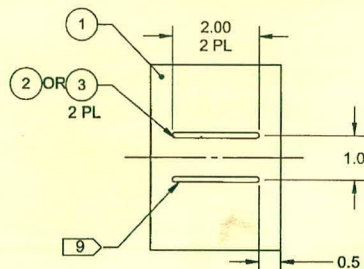
Description Work Order Deviation	Disposition	Completed By 12 18/8/28
Weld spacing is 0.75 instead of 1.00"	Acceptable.	Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

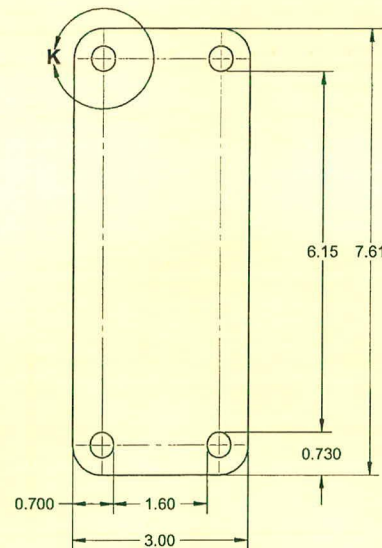
ITEM	QTY -047	P/N	DESCRIPTION
	X	D5489-047	WEARPLATE ASSEMBLY
1	1	D5489-7	WEARPLATE
2	A/R	8259	HARDCOAT SURFACING AUTOMATED WELDING
3	A/R	2059B	HARDCOAT SURFACING MANUAL WELDING



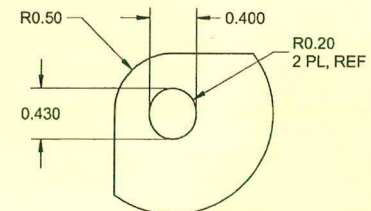
D5489-7 WEARPLATE
(MAKE FROM D5489-7F)



D5489-047 WEARPLATE ASSEMBLY



D5489-7F WEARPLATE
(FLAT PATTERN)



DETAIL K

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 182081 MC
18-08-17

RELEASE

2018 AUG 16

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063"), PER MIL-S-5059 OR AMS 5513 (304), OR AMS 5524 (316), OR ASTM A240, OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.1
- 7) WEIGHT: 0.3 lbs
- 8) COAT ENTIRE TOP CONCAVE SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART QSI 005 4.9
- 9) WELDING: BUILD UP HARD SURFACING 0.06 TO 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILD UP HARD SURFACING 0.06 TO 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

APPROVED

DESIGN	SAD	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	NO	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5489	SHEET 6 OF 7
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
DATE	18.06.14	COPYRIGHT © 2017 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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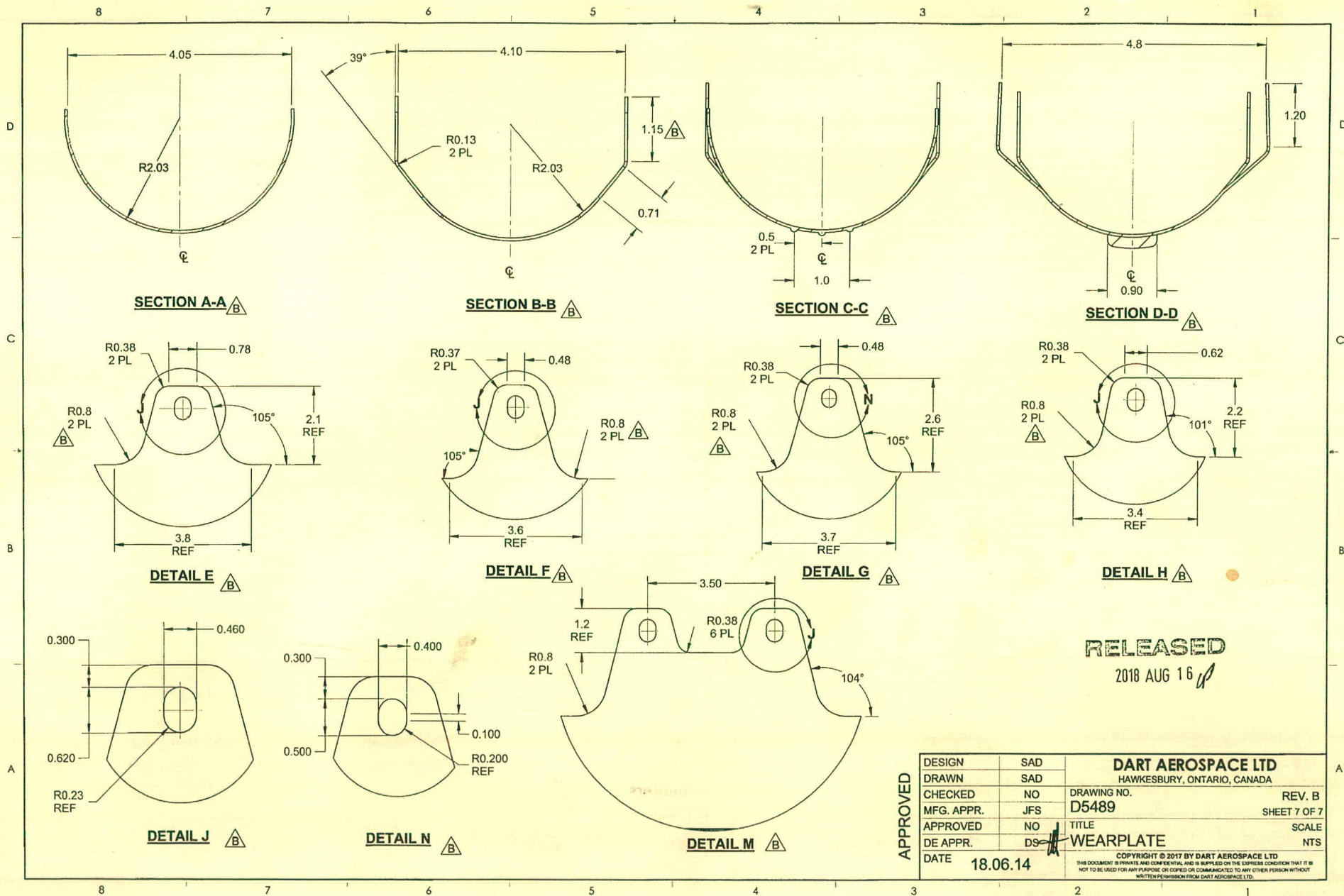


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